

Work Order ID 56092

February 10, 2010 12:12:33 PM



Page 1

Item ID:	D3538-1	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Hinge Bracket					
Start Date:	2/10/10	Start Qty:	10.00		Cust Item ID:	
Required Date:	2/26/10	Req'd Qty:	10.00		Customer:	
Reference:						

Approvals:	Process Plan:		Date:	10-2-10	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3538	Rev A								

100



Bandsaw

Jeaspa Bandsaw

BAND SAW

Memo

Cut blanks 1.500" long

0.00

0.00

DTP 10/02/11

9 78 8

110



HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

1-Machine as per Folio FA651 and Dwg D3538112-Deburr

0.00

0.00

DTP 10/02/11 / MW = 10/02/13

8 2
9 78 8

120



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

MW 10/02/13

8 2
9 78 8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 56092

February 10, 2010 12:12:33 PM



Page 2

Item ID: D3538-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Hinge Bracket

Start Date: 2/10/10 Start Qty: 10.00



Cust Item ID:

Required Date: 2/26/10 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____


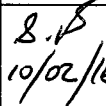
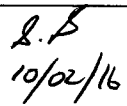
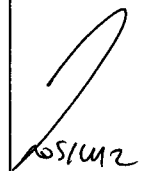
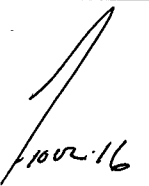
Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		28 10/02/16		8	2		
140 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00		162 10-02-17		8	0		PTO →
150 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum M113170 Memo START TIME: 7:00AM FINISH TIME: 7:30AM	0.00 0.00		⇒ 10-02-18		48	0		

OVEN TEMPERATURE:

3209

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3538-1 PAR #: _____ Fault Category: Machined parts NCR: Yes No DQA: 7 Date: 10-03-01
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: _____ Date: _____

NCR: <u>56092</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/02/16	130	DURING QCR the Inspector Measure two dimension who was under tolerance. Thickness of .125±.010" was		Qty 2 part are affected No replace. Scrap & destroy	 10/02/16	 10/02/16		 10/02/16
		.108". Part vibration & chip build up. R.C. process.						

NOTE: Date & initial all entries

Work Order ID 56092

February 10, 2010 12:12:33 PM



Page 3

Item ID: D3538-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Hinge Bracket

Start Date: 2/10/10 Start Qty: 10.00



Cust Item ID:

Required Date: 2/26/10 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00

BR.

10-02-18

③

4

QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location: C9

0.00



Packaging

Memo

0.00

Packaging

Perp/22 P

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/02/23

MF
10-2-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

February 10, 2010 12:12:39 PM

Page 1

Work Order ID: 56092



Parent Item: D3538-1



Parent Item Name: Hinge Bracket

Start Date: 2/10/10

Required Date: 2/26/10

Comments: IPP Rev:A New Issue 06-10.03 EC

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

M6061T6B1.250X01.25
0

Purchased

No

100

f

52.3800

2.0000



6061-T6 Bar 1.25 x 1.25

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

52.38

106259

14

109058

21.43

110001

16.95

2.000

DJP 10/02/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 56092
Description: Hinge Bracket		Part Number: D3538-1
Inspection Dwg: D3538	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.75	+/-0.030	0.75	✓			
0.375	+/-0.010	0.375	✓			
0.241	+/-0.010	0.241	✓			
0.830	+/-0.010	0.830	✓			
Ø0.172	+0.005/-0.001	0.174	✓			
Ø0.400	+0.006/-0.001	0.400	✓			
0.031	+/-0.010	0.025	✓			
1.31	+/-0.030	1.31	✓			
0.375	+/-0.010	0.375	✓			
0.99	+/-0.030	0.99	✓			
0.125	+/-0.010	0.125	✓			
R0.19	+/-0.030	0.188	✓			
0.083	+/-0.010	0.083	✓			
93°	+/-0.5°	93°	✓			
0.674	+/-0.010	0.674	✓			
R0.38	+/-0.030	0.380	✓			
Ø0.172	+0.005/-0.001	0.173	✓			

Measured by: <i>[Signature]</i>	Audited by: <i>[Signature]</i>	Prototype Approval:	N/A
Date: 10/02/11	Date: 10/02/16	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.05.31	New Issue	KJ/JLM <i>[Signature]</i>	<i>[Signature]</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

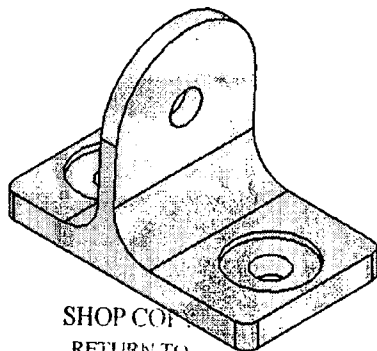
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

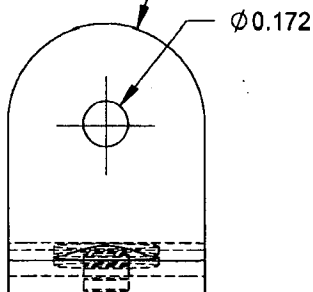
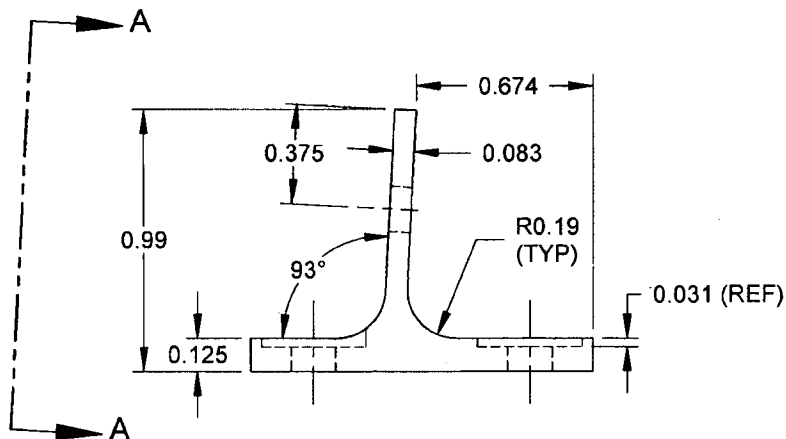
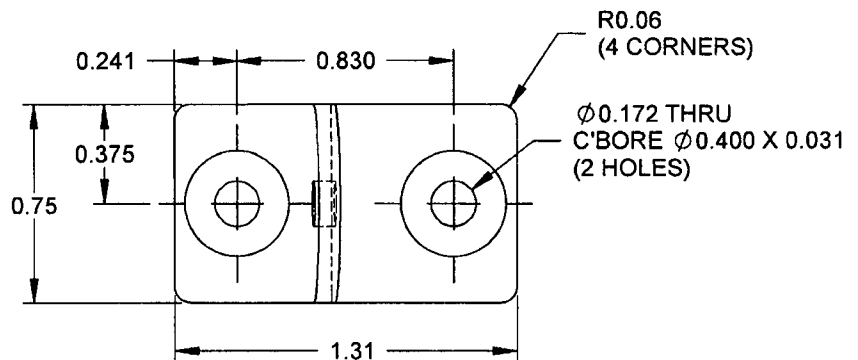
DART

DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>#</i>	DRAWING NO. D3538	REV. A SHEET 1 OF 2
DATE 06.10.13	TITLE HINGE BRACKET		SCALE 1:1
REV A	DATE 06.10.13	DESCRIPTION NEW ISSUE	

RELEASED
06.10.13 #

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *54092*

10-2-10 R0.38 (REF)

**AUXILIARY VIEW A****D3538-1 HINGE BRACKET****NOTES:**

- 1) MATERIAL: 6061-T6 ALUMINUM PER QQ-A-225/8 OR QQ-A-200/8 (REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) IDENTIFY WITH P/N D3538-1 USING FINE POINT PERMANENT INK MARKER

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

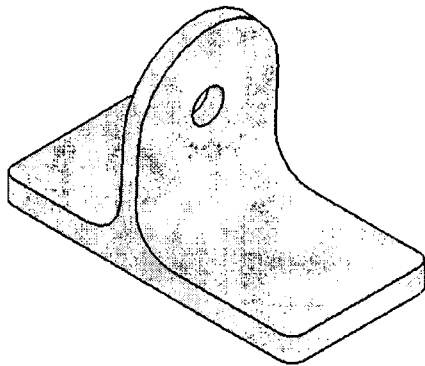
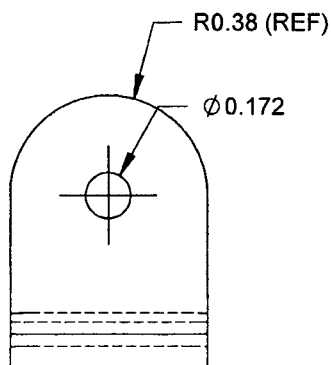
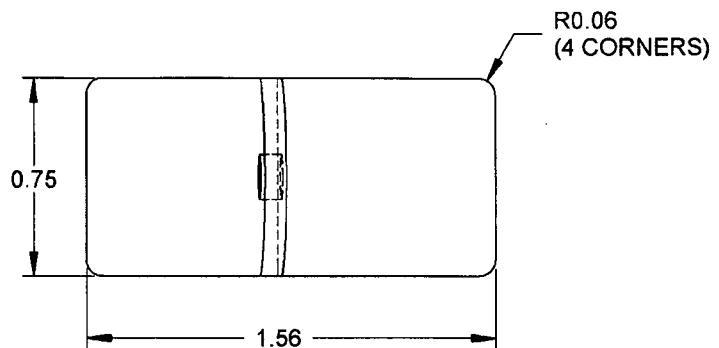
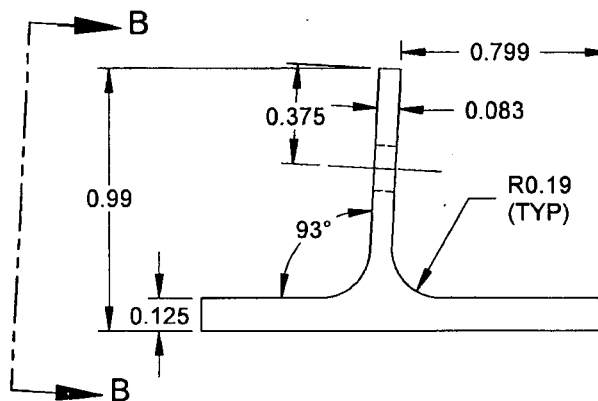
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/02/13	110	Base thickness .125 is not crooked because part was install crooked QL operator error		scrap / No replace	MW 10/02/13	N/A		

NOTE: Date & initial all entries

DART

DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3538	REV. A SHEET 2 OF 2
DATE 06.10.13	TITLE HINGE BRACKET		SCALE 1:1

w/o 56092**RELEASED**
06.10.13**AUXILIARY VIEW B****D3538-3 HINGE BRACKET****NOTES:**

- 1) MATERIAL: 6061-T6 ALUMINUM PER QQ-A-225/8 OR QQ-A-200/8 (REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) IDENTIFY WITH P/N D3538-3 USING FINE POINT PERMANENT INK MARKER

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries